

Work Order ID 55262

January 12, 2010 2:34:21 PM



Page 1

Item ID: D4042-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Short Basket Base Assembly, RH

Start Date: 1/12/10 Start Qty: 1.00



Cust Item ID:

Required Date: 1/25/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

PL

Date: 10-1-12

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4042

PAT PA4 10/01/12

100

Weld per dwg A/R S.S. rod Batch: *M109213*

0.00



Large Fab

Large Fab

Memo

0.00

1- assemble ribs , weld as per dwg D4042 -
inspect before welding mesh
2- tack weld mesh on basket as per dwg D4042 -
3- weld hinges, handel plates and Mounting brackets as per dwg D4042 -
take lid to locate hinge and bracket

PD 10.01.28

Pro

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

PL 10/01/29

PRELIMINARY ISSUE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
100202	1.0	Move Mounting Lug from 2.43 loc to 1.25 in location. weld in place	PD	10.02.01	1	MP 10/02/02	10/02/02
100202	1.0	Move Move Mounting Lug back to its original location of 2.43. weld in place	PD	10.02.01	1	MP 10/02/02	10/02/02

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55262

January 12, 2010 2:34:21 PM



Item ID:	D4042-042	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Short Basket Base Assembly, RH					
Start Date:	1/12/10	Start Qty:	1.00		Cust Item ID:	
Required Date:	1/25/10	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo	0.00							
			QC APPROVAL						
130 	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
Powdercoat Powder Coating	Memo	0.00							
	1- Plug holes prior to								
	IST COAT:								
	START TIME: _____								
	OVEN TEMPERATURE: _____								
	FINISH TIME: _____								
	***** 2nd coat if necessary*****								
	2ND COAT:								
	START TIME: _____								
	OVEN TEMPERATURE: _____								
	FINISH TIME: _____								

QC APPROVAL

10-01-29

Prototype
10-01-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55262

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Page 3

Item ID: D4042-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Short Basket Base Assembly, RH

Start Date: 1/12/10 Start Qty: 1.00



Cust Item ID:

Required Date: 1/25/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									
150	Assemble as per dwg	0.00							
HandFinish	Memo	0.00							
Hand Finishing									
160	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

U 100208

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D4042-042

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Setup Start



Revision ID:

Stop



Item Name: Short Basket Base Assembly, RH

Start Date: 1/12/10 Start Qty: 1.00



Cust Item ID:

Required Date: 1/25/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00




QC

Memo

0.00

Quality Control

POSITIVE RECALL

EFFECTIVE 10-01-29 AUTH 

RELEASED _____ DATE _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 12, 2010 2:34:26 PM

Work Order ID: 55262

Parent Item: D4042-042

Parent Item Name: Short Basket Base Assembly, RH










Start Date: 1/12/10

Required Date: 1/25/10

Comments: IPP RevA: new issue DD 10.01.12 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D4042-043 		Manufactured	No			100	Each	0.0000	1.0000			
Aft Rib Assembly												
D4043-041 		Manufactured	No			100	Each	0.0000	1.0000			
Fwd Rib Assembly												
D4044-043 		Manufactured	No			100	Each	0.0000	2.0000			
Center Rib Assembly												
D4044-041 		Manufactured	No			100	Each	0.0000	1.0000			
Fwd Rib Assembly												
D4042-1 		Manufactured	No			100	Each	0.0000	1.0000			
Fwd Rib												
D4042-5 		Manufactured	No			100	Each	0.0000	1.0000			
Inboard Rib												
D4042-7 		Manufactured	No			100	Each	0.0000	1.0000			
Outboard Rib												
D4042-9 		Manufactured	No			100	Each	0.0000	1.0000			
Fwd Rib												
D4042-13 		Manufactured	No			100	Each	0.0000	1.0000			
Aft Rib												

B55221 PD 10.01.26

B55222 PD 10.01.26

B55223 PD 10.01.26

B55224 PD 10.01.26

B55224 PD 10.01.26

B55225 PD 10.01.26

B55226 PD 10.01.26

B55227 PD 10.01.26

B55229 PD 10.01.26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 55262

Parent Item: D4042-042

Parent Item Name: Short Basket Base Assembly, RH



















Start Date: 1/12/10

Required Date: 1/25/10

Comments: IPP RevA: new issue DD 10.01.12 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D4043-3  Fwd Rib		Manufactured	No			100	Each	0.0000	1.0000 		B55230 PD 10.01.26	
D4043-5  Center Rib		Manufactured	No			100	Each	0.0000	2.0000 		B55231 PD 10.01.26	
D4043-7  Aft Rib		Manufactured	No			100	Each	0.0000	2.0000 		B55232 PD 10.01.26	
D4044-5  Aft Rib		Manufactured	No			100	Each	0.0000	1.0000 		B55233 PD 10.01.26	
D4042-11  Center Rib		Manufactured	No			100	Each	0.0000	1.0000 		B55228 PD 10.01.26	
D4045-1  Lug		Manufactured	No			100	Each	0.0000	3.0000 		B55260 PD 10.01.26	
D4046-1  Mesh Basket Base		Manufactured	No			100	Each	0.0000	1.0000 		B55238 PD 10.01.27 B55218 PD 10.01.27	
D4046-3  Mesh Fwd End		Manufactured	No			100	Each	0.0000	1.0000 		B55217 PD 10.01.28	
D4046-5  Mesh Aft End		Manufactured	No			100	Each	0.0000	1.0000 		B55288 PD 10.01.28	

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Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Page 3

Work Order ID: 55262

Parent Item: D4042-042

Parent Item Name: Short Basket Base Assembly, RH




Comments: IPP RevA: new issue DD 10.01.12 verified by:EC

Start Date: 1/12/10

Required Date: 1/25/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D4016-1 		Manufactured	No			100	Each	0.0000	3.0000			
Hinge Half, Base												
D4021-1 		Manufactured	No			100	Each	0.0000	4.0000			
Handle Plate												
D2581 		Manufactured	No			100	Each	10.0000	2.0000			
Mounting Bracket												

B 55213 PD 10.01.27

B 55219 PD 10.01.27

B 54862 PD 10.01.28

Warehouse Location

Main Warehouse

Loc	Qty	Loc Code
ST	7	
46086	2	
48428	1	
51120	4	

Main Warehouse

Loc	Qty	Loc Code
WA	3	
50872	1	
51745	2	

D2931
 Manufactured No 150 Each 929.0000 2.0000

Bumper

Warehouse Location

Main Warehouse

Loc	Qty	Loc Code
ST	929	
46064	929	

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 55262

Parent Item: D4042-042

Parent Item Name: Short Basket Base Assembly, RH



Start Date: 1/12/10

Required Date: 1/25/10

Comments: IPP RevA: new issue DD 10.01.12 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD8 		Purchased	No			150	Each	806.0000	2.0000			
Washer												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	806	
107091	9	
108335	11	
110382	48	
110917	3	
111578	60	
112385	675	

MS20600-AD4W3

Purchased

No

150

Each

2,509.000

2.0000



Cherry Rivets

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	2509	
102929	37	
104715	10	
106375	494	
107939	1000	
111636	968	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

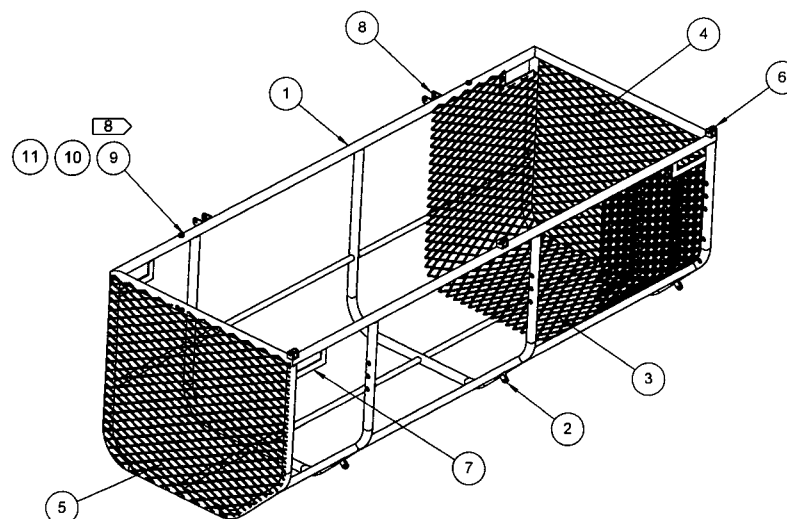
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4042-041	SHORT BASKET BASE ASSY, LH
1	1	D4042-101	BASKET BASE FRAME ASSY, LH
2	3	D4045-1	LUG
3	1	D4046-1	MESH BASKET BASE
4	1	D4046-3	MESH FWD END
5	1	D4046-5	MESH AFT END
6	3	D4016-1	HINGE HALF, BASE
7	4	D4021-1	HANDLE PLATE
8	2	D2581	MOUNTING BRACKET
9	2	D2931	BUMPER
10	2	AN960JD8	WASHER
11	2	MS20600AD4W3	RIVET



PRELIMINARY ISSUE

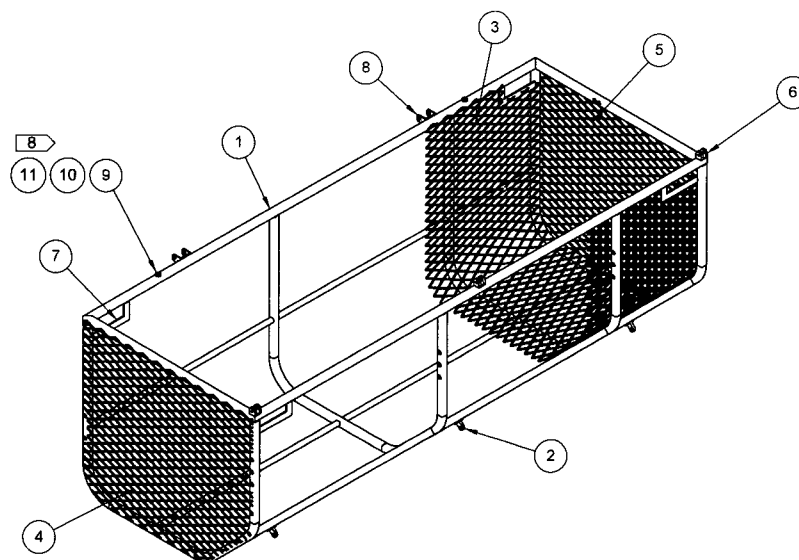
10.01.21

D4042-041 SHORT BASKET ASSY, LH
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 28.82 lbs APROX
- 8) INSTALL AFTER FINISH
- 9) TRIM LOCALLY AS REQUIRED TO CLEAR FASTENERS/STRUCTURE
- 10) WELD PER DART QSI 004

PA4	ADD DETAIL VIEW P & Q (ZN A7-5, A7-8); FLIP VIEW (ZN A4-10)	RF	10.01.21
PA3	CORRECT P/N TYPO (ZN B2-1, A5-2); REVISE NOTES (ZN A8-1, A8-2, C6-3, D2-3, A4-4, C8-6, D2-6, D2-7, C5-9, A8-10); ORGANIZED TABLE (ZN D3-5, D3-8); ADD DIMENSION (ZN A3-10); RENAME P/N (ZN D3-1, D3-2, A6-5, A6-8, D4-11, C4-11, B4-11); ADD BILL OF MATERIAL (ZN D3-9)	RF	10.01.18
PA2	NEW ISSUE	RF	09.12.22
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. PA4
MFG. APPR.		D4042	SHEET 1 OF 11
APPROVED		TITLE	SCALE
DE APPR.		SHORT BASKET BASE ASSY	NTS
DATE	10.01.21	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



ITEM	QTY -042	P/N	DESCRIPTION
	X	D4042-042	SHORT BASKET BASE ASSY, RH
1	1	D4042-102	BASKET BASE FRAME ASSY, RH
2	3	D4045-1	LUG
3	1	D4046-1	MESH BASKET BASE
4	1	D4046-3	MESH FWD END
5	1	D4046-5	MESH AFT END
6	3	D4016-1	HINGE HALF, BASE
7	4	D4021-1	HANDLE PLATE
8	2	D2581	MOUNTING BRACKET
9	2	D2931	BUMPER
10	2	AN960JD8	WASHER
11	2	MS20600AD4W3	RIVET

55262



NOTES:

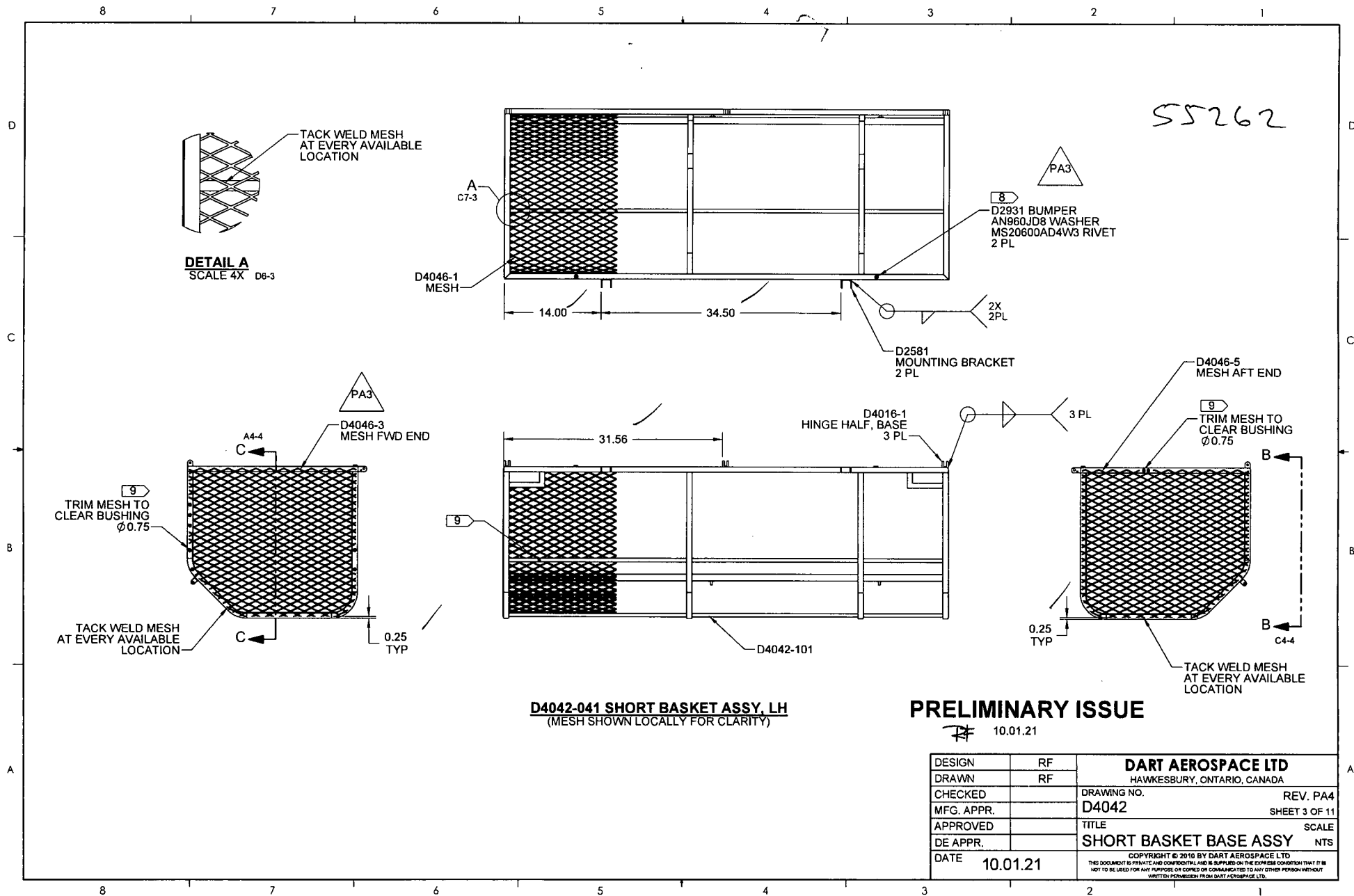
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 28.82 lbs APROX
- 8) INSTALL AFTER FINISH
- 9) TRIM LOCALLY AS REQUIRED TO CLEAR FASTENERS/STRUCTURE
- 10) WELD PER DART QSI 004

D4042-042 SHORT BASKET ASSY, RH
(MESH SHOWN LOCALLY FOR CLARITY)

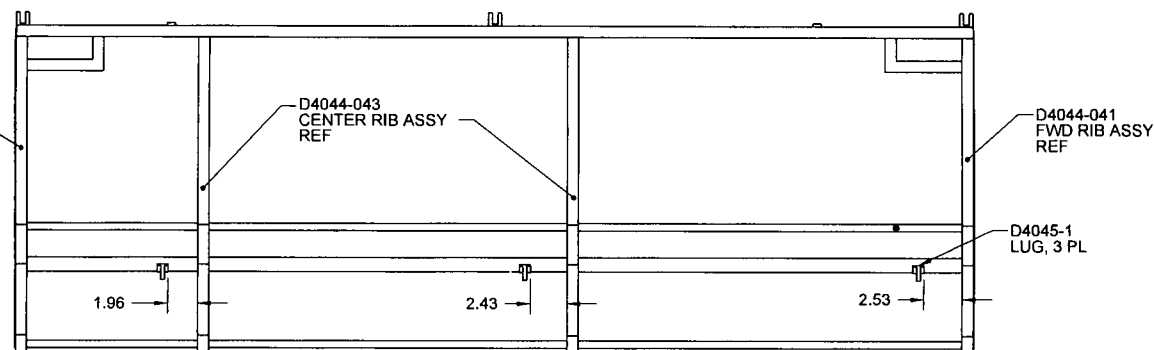
PRELIMINARY ISSUE

10.01.21

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA4
MFG. APPR.		D4042	SHEET 2 OF 11
APPROVED		TITLE	SCALE
DE APPR.		SHORT BASKET BASE ASSY	NTS
DATE	10.01.21	COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



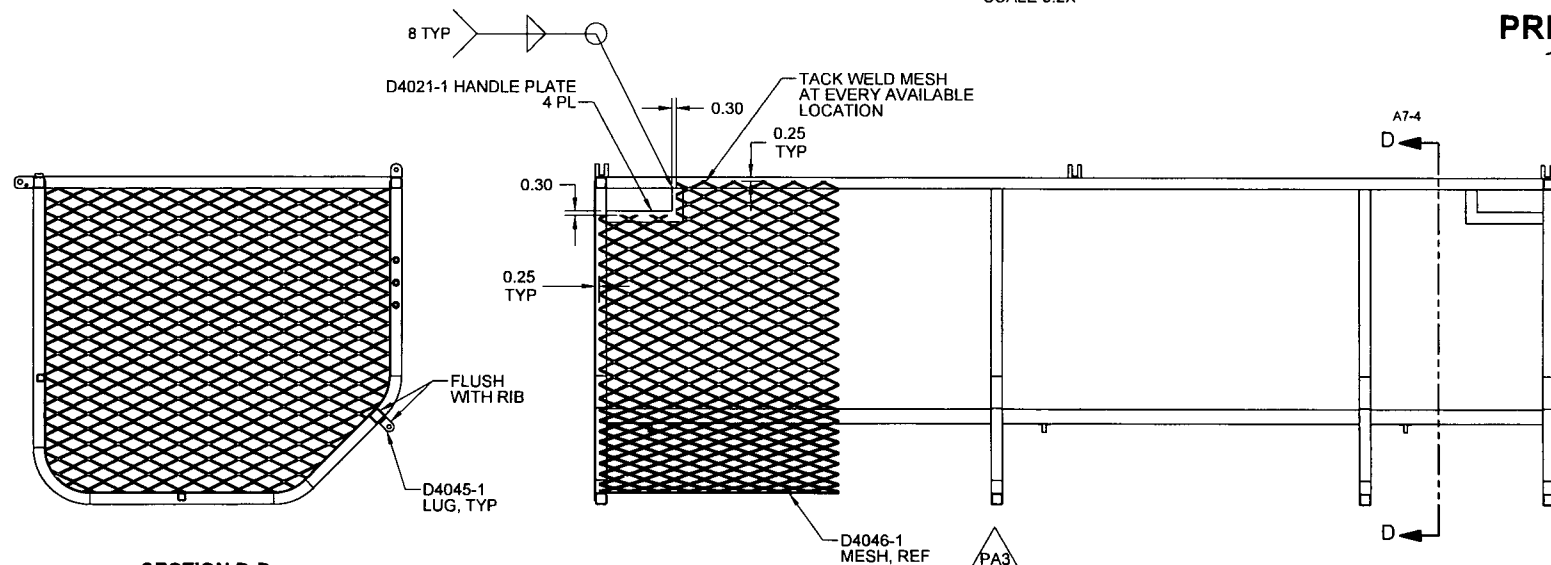
55262



VIEW B-B B1-3
(MESH NOT SHOWN FOR CLARITY)
SCALE 3:2X

PRELIMINARY ISSUE

10.01.21

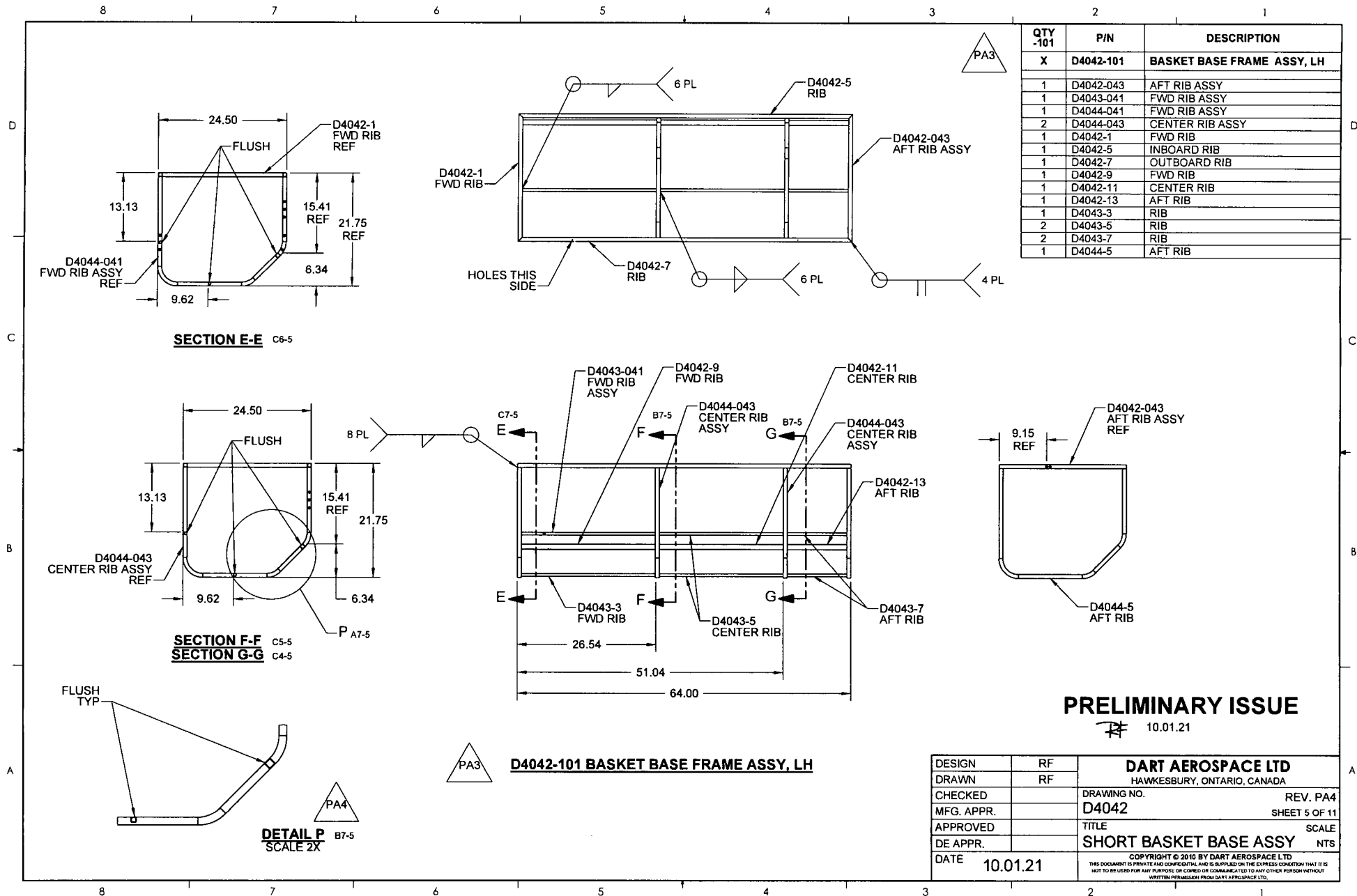


SECTION C-C C7-3
SIMILAR OPPOSITE VIEW
(MESH SHOWN LOCALLY FOR CLARITY)
SCALE 3:2X

SECTION D-D C2-4
TYPICAL

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA4
MFG. APPR.		D4042	SHEET 4 OF 11
APPROVED		TITLE	SCALE
DE APPR.		SHORT BASKET BASE ASSY	NTS
DATE	10.01.21	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

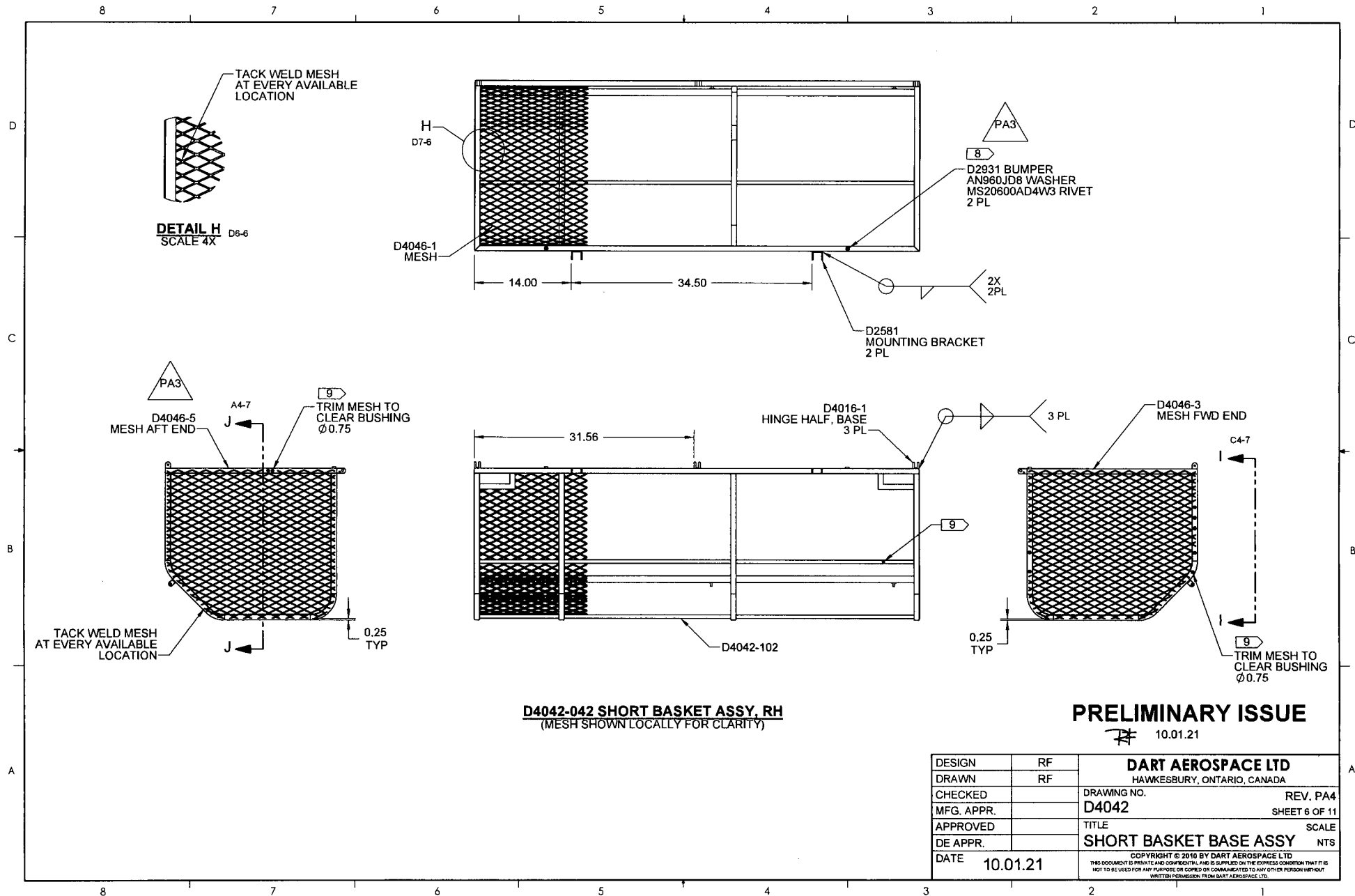
55262



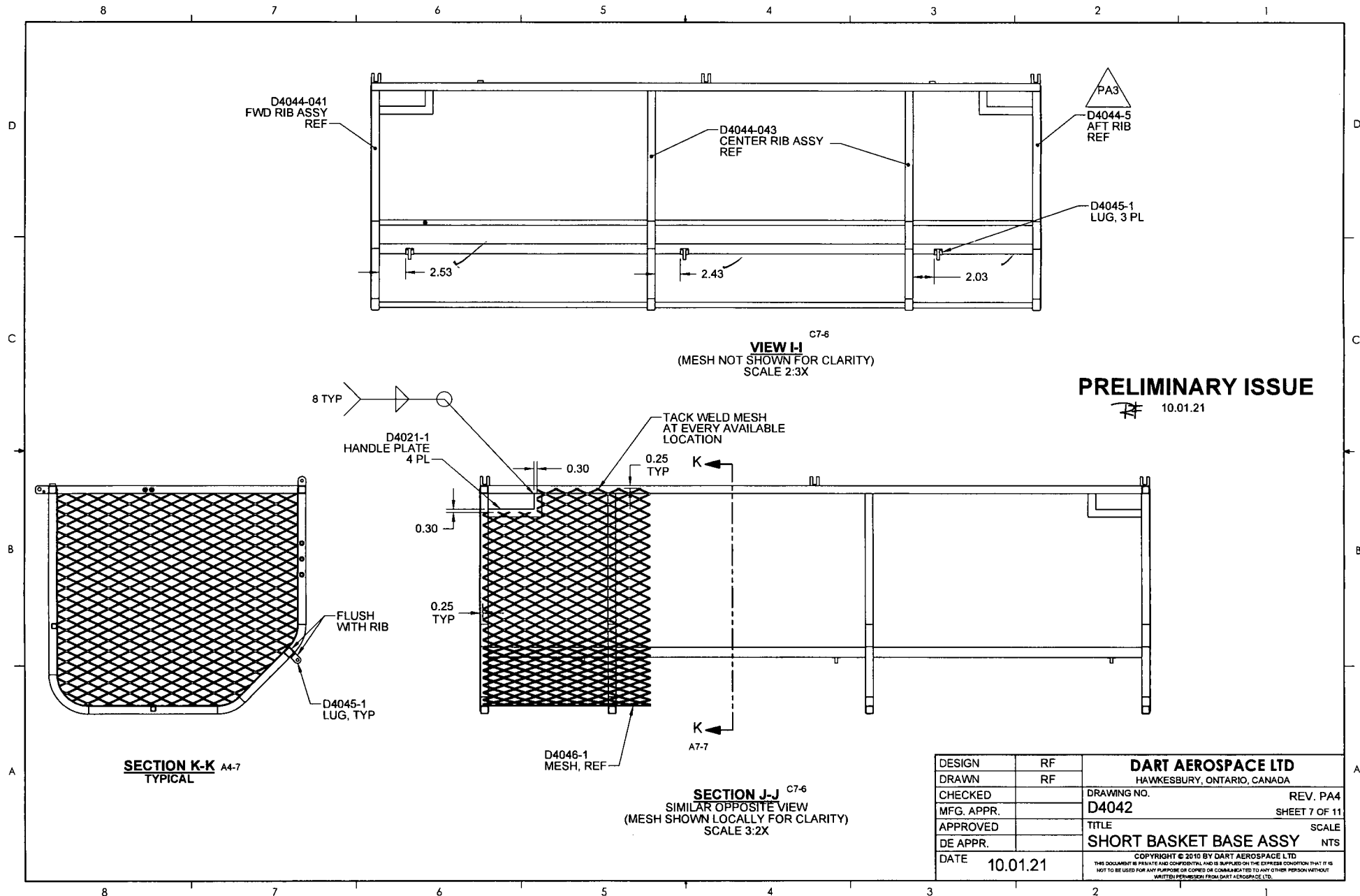
QTY -101	P/N	DESCRIPTION
X	D4042-101	BASKET BASE FRAME ASSY, LH
1	D4042-043	AFT RIB ASSY
1	D4043-041	FWD RIB ASSY
1	D4044-041	FWD RIB ASSY
2	D4044-043	CENTER RIB ASSY
1	D4042-1	FWD RIB
1	D4042-5	INBOARD RIB
1	D4042-7	OUTBOARD RIB
1	D4042-9	FWD RIB
1	D4042-11	CENTER RIB
1	D4042-13	AFT RIB
1	D4043-3	RIB
2	D4043-5	RIB
2	D4043-7	RIB
1	D4044-5	AFT RIB

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. PA4
MFG. APPR.		D4042	SHEET 5 OF 11
APPROVED		TITLE	SCALE
DE APPR.		SHORT BASKET BASE ASSY	NTS
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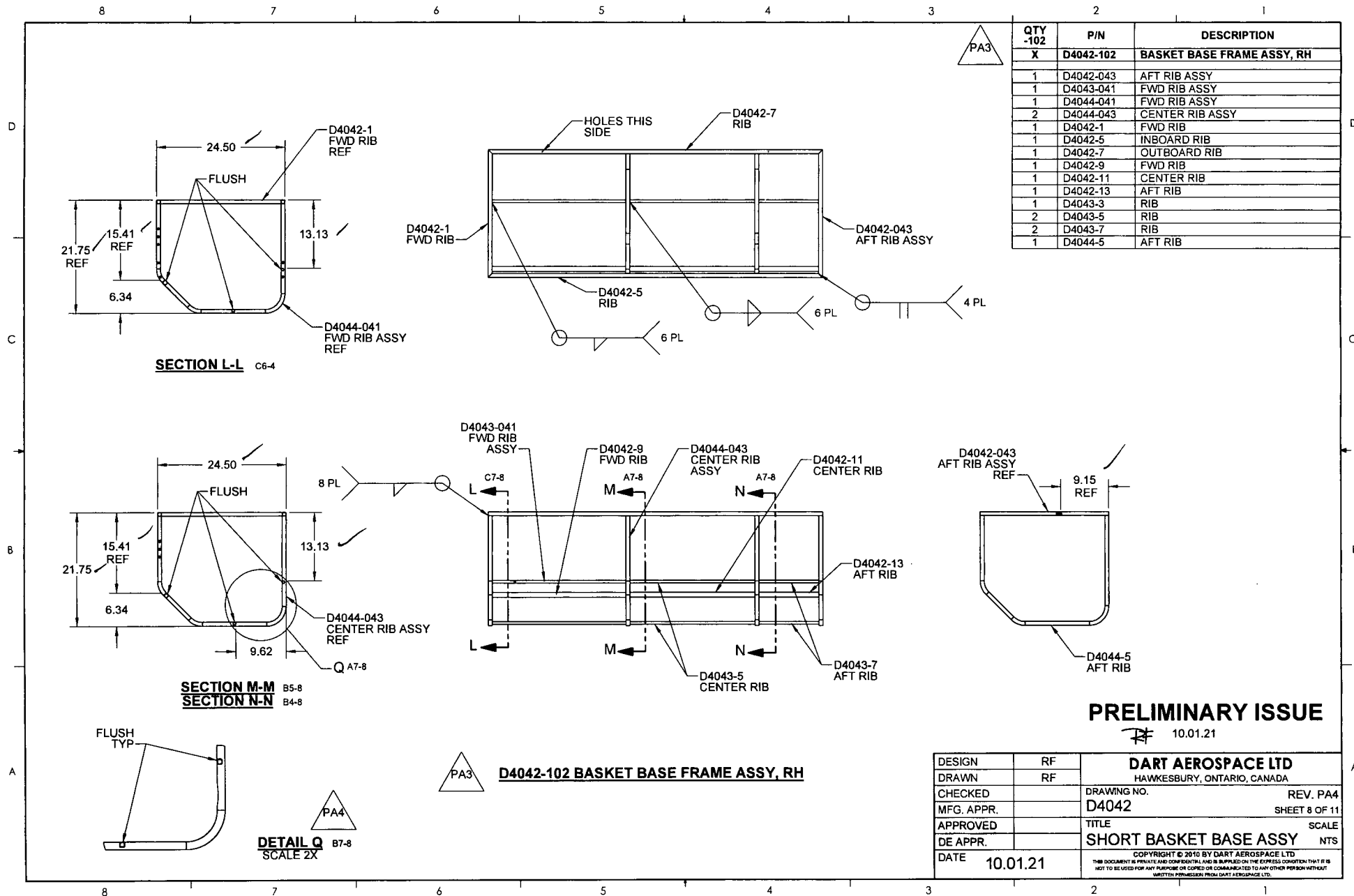
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